

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012678**Date Inspected:** 07-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu Xian Ping			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:			

Summary of Items Observed:

On this day Caltrans OSM Quality Assurance (QA) Inspector Daniel Barrentine was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port

Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

In- Process Inspections:

Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report #B-CWR1096 (for ZPMC UT Reject) of 11TR1-026. Welder is identified as 045240/058245. ZPMC Quality Control (QC) is identified as Zhan Hai Feng. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-2G (2F)-Repair-1. Welding appears to conform to the requirements of the WPS and WRR used.

Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report #B-CWR1096 (for ZPMC UT Reject) of 11TR2-011. Welder is identified as 045209. ZPMC Quality Control (QC) is identified as Zhan Hai Feng. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-2G (2F)-Repair-1. Welding appears to conform to the requirements of the WPS and WRR used.

Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report #B-CWR10062 (for ZPMC UT Reject) of 10TR1-003. Welder is identified as 045203. ZPMC Quality Control (QC) is identified as Zhan Hai Feng. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-2G (2F)-Repair-1. Welding appears to conform to the requirements of the WPS and WRR used.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report #B-WR10138 (for ZPMC UT Reject) of 11TR4-001; Weld 014. Welder is identified as 204342. ZPMC Quality Control (QC) is identified as Shin Jian Guo. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-2G (2F)-Repair-1. Welding appears to conform to the requirements of the WPS and WRR used.

Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report #B-WR10148 (for ZPMC UT Reject) of 10 TR3-027. Welder is identified as 215248. ZPMC Quality Control (QC) is identified as Zhong Chong Biao. Weld Procedure Specification (WPS) is identified as WPS-345-SMAW-1G (1F)-Repair. Welding appears to conform to the requirements of the WPS and WRR used.

Flux Cored Arc Welding (FCAW) of 20TR2-026; Weld 011. Welder is identified as 059450. ZPMC Quality Control (QC) is identified as Xiang Feng Feng. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-Tc-U5-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of 20TR1-008; Weld 005. Welder is identified as 219188. ZPMC Quality Control (QC) is identified as Xiang Feng Feng. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-Tc-U5-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of 20TR2-018; Weld 011. Welder is identified as 215397. ZPMC Quality Control (QC) is identified as Xiang Feng Feng. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-Tc-U5-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report #B-WR10292 (for ZPMC UT Reject) of 11 TR3-007- 014. Welder is identified as 053742. ZPMC Quality Control (QC) is identified as Cui Jun Jie. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-2G (2F)-Repair-1. Welding appears to conform to the requirements of the WPS and WRR used.

Heat straightening performed on 10 TR1-009 and 10 TR1-005 pursuant to HSR # HSR1 (B) 8066. Quality Control (QC) was identified as Cui Jun Jie.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Barrentine,Daniel

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer